

Work Order ID 51926

Wednesday, September 09, 2009 11:36:22 A



Page 1

Item ID: D3407-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Tow Ring

Start Date: 9/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/21/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: RL Date: 09-9-09 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3407	Rev E								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004

A/R TIG174 ROD Batch: M101972

M101972

AD 09.10.06 (12)

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

Cpl 09 10 06

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) 807/10/06

(12) /

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Item Name: Tow Ring

Start Date: 9/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/21/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112260

0.00

⇒ 09/10/13

(12)

Ø

Memo

Mask Threaded Section

START TIME: 11:15AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:45AM

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

09-10-13

(12)

Memo

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

0.00

09/10/13

(12)

Memo

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Item ID: D3407-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Tow Ring

Start Date: 9/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/21/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/14 *[Signature]*
[Signature] 09-10-14

Picklist Print

Wednesday, September 09, 2009 11:36:27 AM

Page 1

Work Order ID: 51926



Parent Item: D3407-041RevE



Parent Item Name: Tow Ring

Start Date: 9/11/2009

Required Date: 9/21/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3407-1RevE 		Manufactured	No			100	Each	9.0000	12.0000			
Stem												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST93

50303

9

9

D3407-5RevE

Manufactured No

100

Each

0.0000

12.0000



Ring

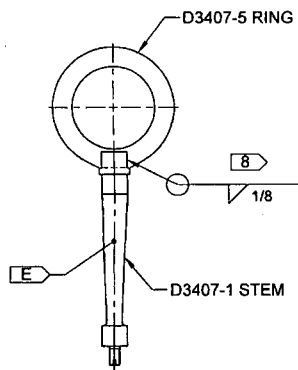
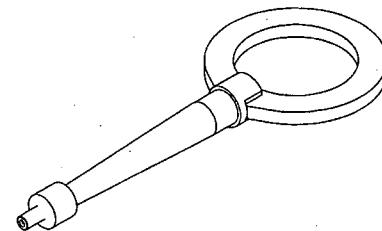


① B51616 → 12
09.10.06

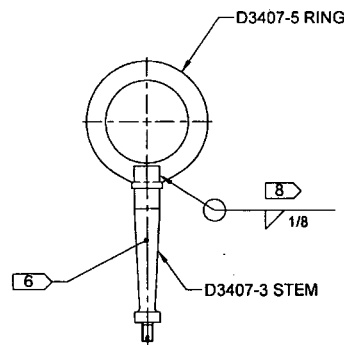
① B51633 → 12
09.10.06

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

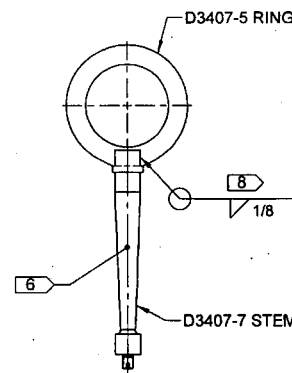
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51924



D3407-041 TOW RING



D3407-043 TOW RING

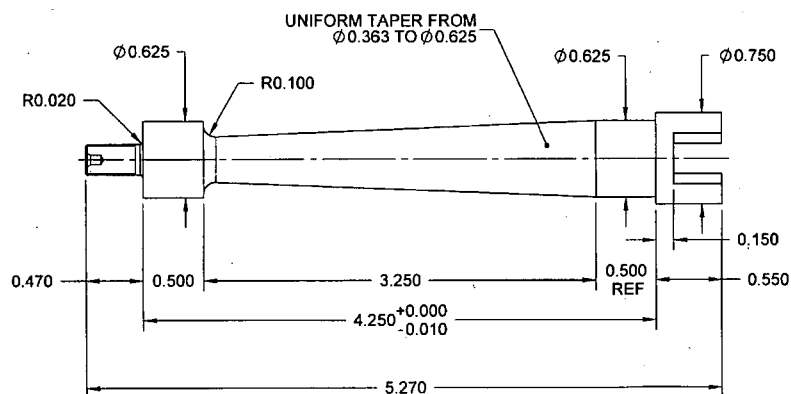
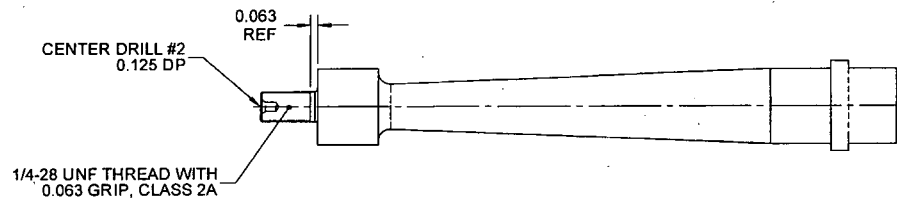


D3407-045 TOW RING

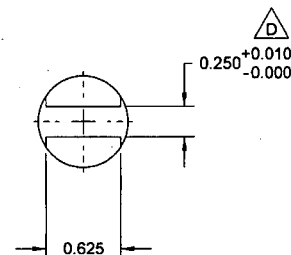
RELEASED
07-08-01/11/13

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DRAWN	CHECKED	MFG. APPR.
APPROVED	DE APPR.	DATE	08.07.23
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D3407-1 STEM

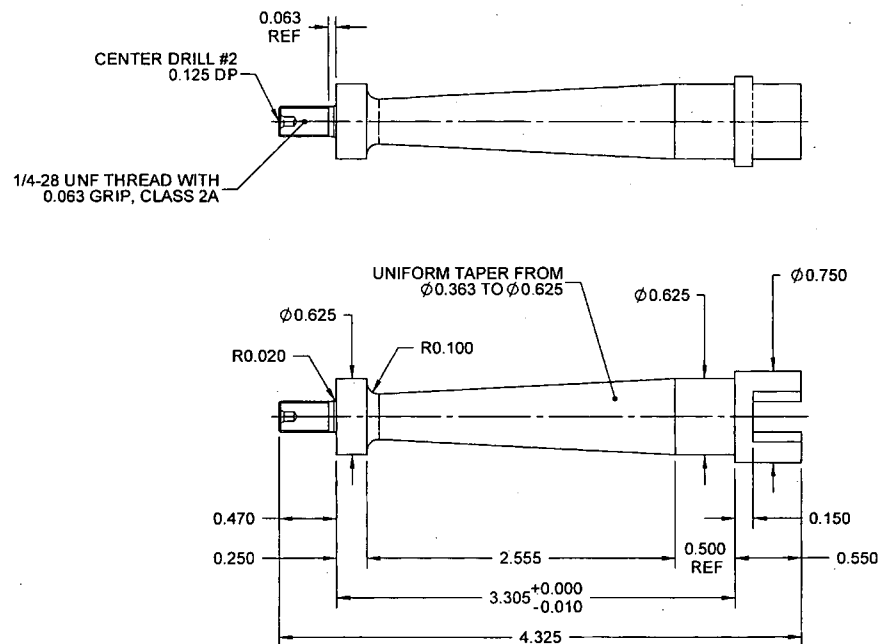


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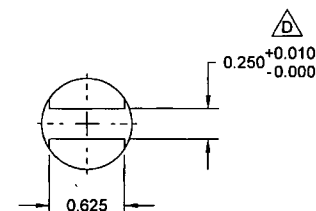
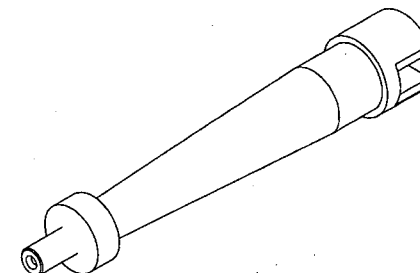
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- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

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

D3407-3 STEM

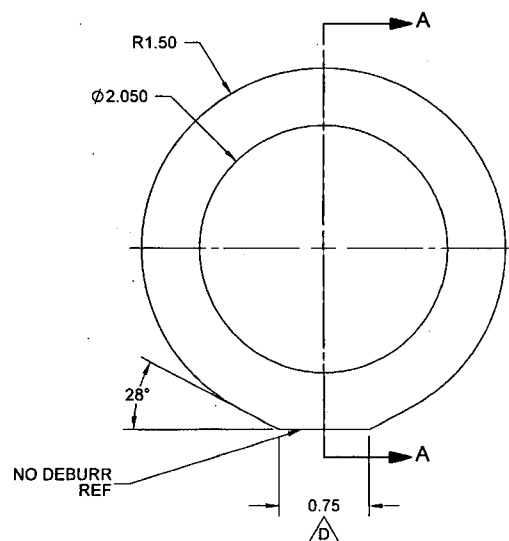


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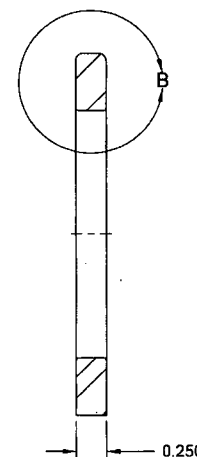
RELEASED
08-05-01

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

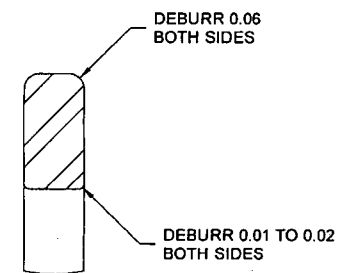
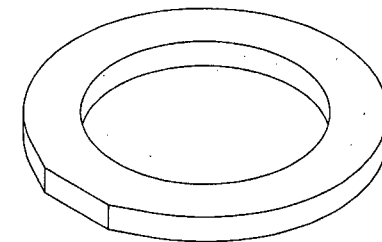
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D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

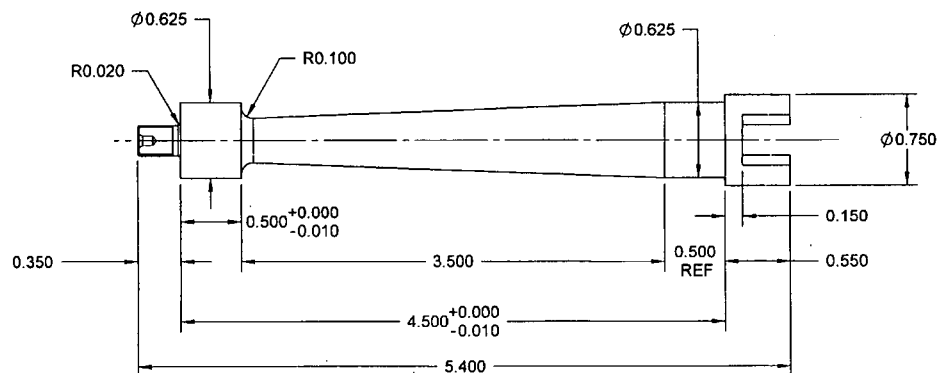
51926
RELEASED
06-08-2014

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	90	DART AEROSPACE USA, INC.	
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0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

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